

Work Order ID 122662

Tuesday, July 22, 2014 8:42:57 AM

\*122662\*

Page 1

Item ID: D4653-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Collar

Start Date: 8/14/14 Start Qty: 35.00

\*35\*

Cust Item ID:

Required Date: 8/14/14 Req'd Qty: 35.00

\*35\*

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-7-23

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4653

REV A

100

Cut blanks as per folio

0.00

\*100\*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 3.600"

29

14-7-28

DAS  
13  
9-89

105

Hardinge CNC LATHE SMALL

0.00

\*105\*

Doosan

Memo

0.00

Doosan Lathe

Machine as per folio FB115

FOLIO REV: 51A

DWG REV: A

Deburr

28

1

14-7-28

DAS  
13  
9-89

ATC

DQA:

Date:

14/08/27



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

14/8/26

Work Order update only ☐

Work Order: <u>122662</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>					
Part No. <u>D4653-3</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>14-4176</u>		Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>		
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-7-29	105	1	<del>1</del> part scrap offset for tool not entered correctly RC operator error was not really worth	DAS 16 9-89  Q52042 14/08/18	- Scrap no replace  \$54.72	14-7-29	14/08/04	DAS 16 9-89  Q52042 14/08/18
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

no Reverification



# Work Order ID 122662

Tuesday, July 22, 2014 8:42:57 AM

**\*122662\***

Page 2

Item ID: D4653-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Collar  
 Start Date: 8/14/14 Start Qty: 35.00 **\*35\*** Cust Item ID:  
 Required Date: 8/14/14 Req'd Qty: 35.00 **\*35\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 13 9-89
110 <b>*110*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00				28	1		14-7-28	
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				8	0			DAS 08 9-89
121 <b>*121*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				8			7/6/14-8-12	

# Work Order ID 122662

\*122662\*

Page 3

Tuesday, July 22, 2014 8:42:57 AM

Item ID: D4653-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Collar  
 Start Date: 8/14/14 Start Qty: 35.00 \*35\* Cust Item ID:  
 Required Date: 8/14/14 Req'd Qty: 35.00 \*35\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC7-Inspect Chemical Conversion Coat	0.00							
*123*						8	8	8	14/08/12
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>ST114</u>	0.00							
*130*						8X		DAS 28 9-89	AUG 12 2014
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-13  
 MLJ 14-08-12

# Picklist Print

Tuesday, July 22, 2014 8:42:56 AM

Page 1

Work Order ID: 122662

\*122662\*

Parent Item: D4653-3

\*D4653-3\*

Parent Item Name: Collar

Start Date: 8/14/14

Required Date: 8/14/14

Start Qty: 35.00

Required Qty: 35.00

Comments: IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500		Purchased		No			f	9.0000		8.75			68-6 84 900
*M6061T6R3 500*										**	14-7-28		
6061 RD bar 3.50													

Location

Loc Qty

Loc Code

MAT005

9

m128054

1

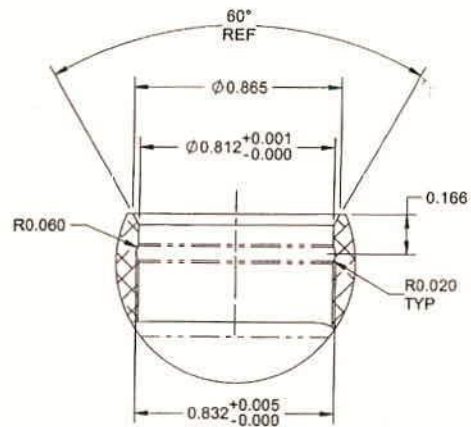
m129845

8

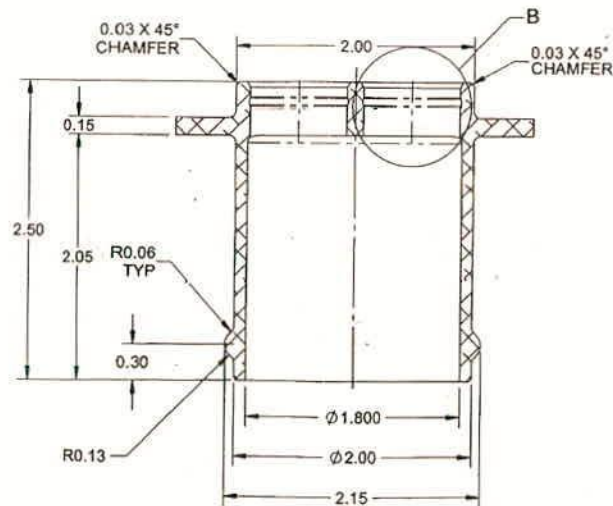
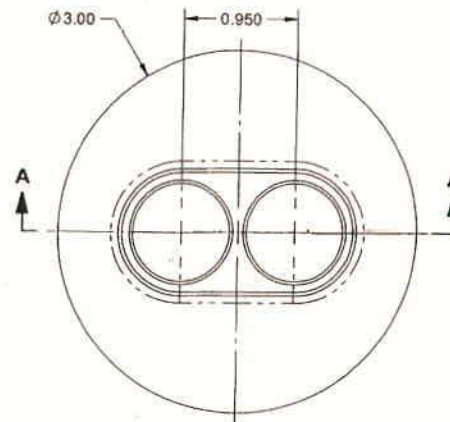
1200+  
821



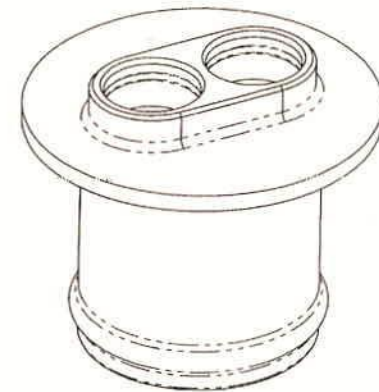




**SECTION B-B**  
SCALE 2X, 2 PL



**SECTION A-A**



**D4653-3 COLLAR**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO *MP172662*  
*14-7-23*

**RELEASED**  
2012-11-05  
*MP*

DESIGN	<i>14</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>14</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>14</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>14</i>	D4653	SHEET 3 OF 6
APPROVED	<i>14</i>	TITLE	SCALE
DE APPR.	<i>14</i>	<b>VENT MANIFOLD ASSY</b>	
DATE	12.07.25	NTS	
COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			